INSTRUCTIONS FOR FN SCAR® 16S AND 17S BARREL CHANGE

This instruction sheet covers the removal and installation of the FN SCAR 16S/17S barrel. Consult your owner's manual for information on the safe handling, maintenance and operation of your FN SCAR. If you do not have an owner's manual, you can download a copy or request a hard copy by visiting fnamerica.com. If you have questions or require assistance, please contact us at customerservice@fnamerica.com or by phone at 1-800-635-1321, option 4.

Accessory barrels chambered in 6.5mm Creedmoor are supplied with a new high-pressure bolt assembly and firing pin. When switching barrels to 6.5 CM, the bolt and firing pin used with that barrel must be the HP bolt and firing pin design. The high-pressure bolt can be identified by the marking "HP" near the MPI marking on the bolt body. The corresponding firing pin will have three rings on its tail (Highlighted in red, Figure 1).

Rifles using the 7.62x51mm barrel may use either the original bolt and firing pin design or the new high-pressure design. SCAR 17S rifles manufactured after September 2022 will all have the high-pressure bolt and firing pin regardless of caliber. All SCAR 16S rifles use a single bolt and firing pin.

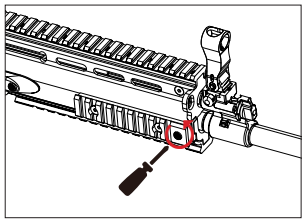
Accessory barrels chambered in 5.56x45mm and 7.62x51mm do not include a new bolt assembly or firing pin.

FIGURE 1 High-Pressure Bolt and Firing Pin included with 6.5 CM Barrels.

BARREL ASSEMBLY REMOVAL

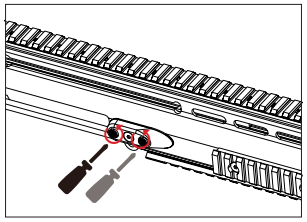
1. Ensure your firearm is completely unloaded and contains no ammunition as described in your owner's manual.
2. Disassemble your firearm as described in Section 19 of your owner's manual by removing the trigger module, moving parts assembly and buttstock assembly.
3. Using a TORX T-25 wrench, loosen the two forward barrel support screws (one on each side) by turning them COUNTERCLOCKWISE until the screws reach their end of travel (Figure 2). The screws will pop out slightly when disengaged from their threads. They SHOULD NOT be completely removed from the receiver.
4. Using a TORX T-25 wrench, loosen the four rear barrel extension screws (two on each side) by turning them COUNTERCLOCKWISE until the screws reach their end of travel (Figure 3). The screws will pop out slightly when disengaged from their threads. They SHOULD NOT be completely removed from the receiver (Figure 4).
5. Remove the barrel assembly by pushing forward on the chamber area of the barrel extension until the rear barrel extension lugs are visible in the cutaway, recessed portion of the receiver frame (Figures 5 and 6). Lift the barrel assembly up and out of the receiver frame (Figure 7).

FIGURE 2



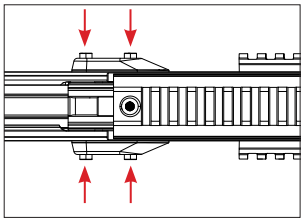
Loosen forward barrel support screws.

FIGURE 3



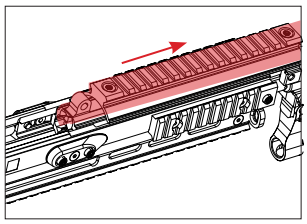
Loosen barrel extension screws.

FIGURE 4



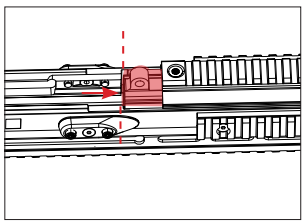
Screws pop out slightly.

FIGURE 5



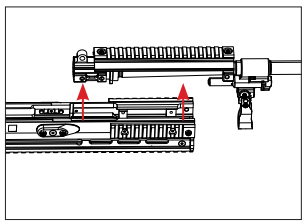
Push barrel assembly forward.

FIGURE 6



Barrel extension positioned in cut-away.

FIGURE 7



Lift barrel out.

If changing the caliber to 6.5mm Creedmoor, remove the bolt assembly from the moving parts assembly as explained in Section 19.4 of the owner's manual. Remove the original bolt and firing pin and reassemble with the supplied high-pressure bolt and firing pin.

NOTICE: When switching bolts and firing pins, both must be switched. The new firing pin will not work in the old bolt and vice versa.

Rifles using the 7.62x51mm barrel may use either the original bolt and firing pin design or the new high-pressure design so switching bolts in the moving parts is not necessary when installing a 7.62x51mm barrel. SCAR 16S rifles use all the same bolt and firing pin.

WARNING:

Before performing any of these tasks on the FN SCAR, place the safety in the on safe position, remove the magazine, open the action and ensure the chamber is empty as explained in Section 15.1 of the owner's manual. Always keep the muzzle pointed in a safe direction. Failure to follow these warnings may result in serious injury or death.

CAUTION:

Before performing a barrel change, please fully read and completely understand these instructions, and ensure you have the tools and knowledge to complete the installation.

CAUTION:

In order to avoid damage to the barrel extension screws and receiver assembly, it is recommended that a torque wrench preset for 62 inch-pounds (7Nm) be utilized during installation of the barrel assembly. Verify before beginning this procedure that your torque wrench is calibrated in inch-pounds and not in foot-pounds. A torque wrench calibrated in foot-pounds will exert too much force and will likely strip the threads and/or break the screw.

Do not attempt to remove any screws on your FN SCAR firearm other than those prescribed during barrel removal. All barrel screws have TORX T-25 heads and are captive, meaning once they are loosened, they are still retained in their threaded holes in the receiver assembly to help prevent their loss or damage. Do not attempt to completely remove these screws from the receiver during barrel removal.

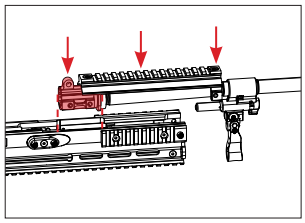
CAUTION:

Removing the barrel assembly from the upper receiver frame without ensuring the barrel extension clears the cutaway, recessed portion of the upper receiver frame could result in damage to the frame.

BARREL ASSEMBLY INSTALLATION

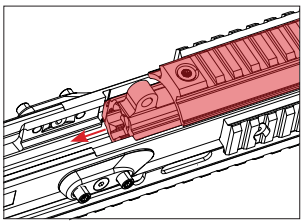
1. Insert the barrel assembly ensuring the barrel extension lugs fall freely into the cutaway, recessed portion in the receiver frame (Figure 8). Align the barrel extension lugs with the guide channel, sliding the barrel assembly rearward until it is fully seated in the receiver frame and all barrel extension screws are aligned with the barrel assembly (Figure 9). Take care to guide the front barrel support into the front of the receiver (Figure 10).
2. Using the torque wrench set at 62 inch-pounds (7Nm) and a TORX T-25 adapter, tighten the barrel screws starting at the rear of the barrel extension (alternating sides) and moving forward on the rifle (Figure 11). When tightening the screws be sure to apply a downward pressure and tighten by turning them CLOCKWISE. There should be an audible and/or tactile signature from the torque wrench when they reach the proper torque setting of 62 inch-pounds (7Nm) (Figures 12 and 13).

FIGURE 8



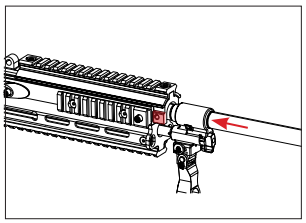
Align barrel extension with cut-away opening in receiver.

FIGURE 9



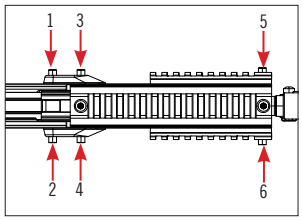
Slide barrel assembly rearward.

FIGURE 10



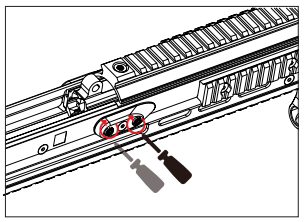
Guide front barrel support into receiver.

FIGURE 11



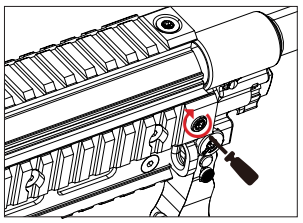
Barrel screw torque sequence.

FIGURE 12



Tighten barrel extension screws.

FIGURE 13



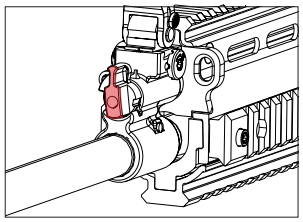
Tighten forward barrel support screws.

ADJUSTING GAS REGULATOR

The gas regulator and piston on the FN SCAR are designed to keep excess carbon from accumulating on the bolt carrier assembly. Most of the carbon buildup is blown out of the vent hole in the front of the regulator. It is recommended that the gas regulator be cycled 2-3 times prior to placing it on the required setting. This will ensure the gas regulator is on the right setting and that it continues to move freely. Positions of the gas regulator as viewed from the muzzle end:

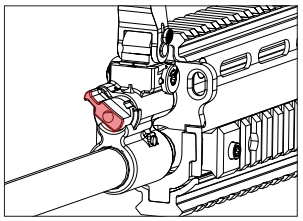
1. 12 O'clock setting - Standard operations (Figure 14).
2. 10 O'clock setting - Suppressed operations. Does not guarantee safe and reliable operation with all suppressors (Figure 15). Refer to the Warning for further information.
3. 4 O'clock setting - Disassembly, cleaning and reassembly (Figure 16).

FIGURE 14



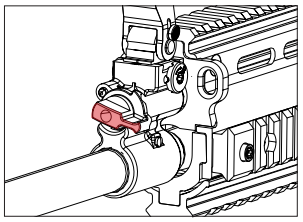
Gas Regulator - Standard setting.

FIGURE 15



Gas Regulator - Suppressed setting

FIGURE 16



Gas Regulator - Disassembly and reassembly position.

It is recommended to disassemble, inspect and clean the following components every 1,000 rounds: gas regulator, gas piston, and gas regulator housing. You should also inspect and clean the muzzle device during routine maintenance. DO NOT ATTEMPT TO REMOVE THE MUZZLE DEVICE FROM THE BARREL.

EFFECTS OF DIFFERENT BARREL LENGTHS AND CALIBERS

1. Due to the firearm's modular design, the FN SCAR can be configured to different barrel lengths and calibers. The operator MUST be aware of which barrel and caliber are installed and the changes that will result in the type of ammunition being used, in firearms zero and ballistic performance.
2. Your FN SCAR will need to be re-zeroed each time after changing the barrel. Be aware that various types of ammunition may perform differently when fired from each barrel.
3. Be sure of which caliber is installed in your rifle before firing. The caliber will be marked on the barrel in front of the gas block or near the muzzle on the left side.

ADDITIONAL INFORMATION

If you do not have an owner's manual, you can download a copy or request a hard copy by visiting fnamerica.com. If you have questions or require assistance, please contact us at customerservice@fnamerica.com or by phone at 1-800-635-1321, option 4.

An instructional video demonstrating a barrel change on the FN SCAR 16S/17S can be found at fnamerica.com

WARNING:

Be aware that barrels shorter than 16-inches are strictly regulated for civilian purchase, possession and/or ownership by federal law. Before attaching a barrel shorter than 16-inches or a sound suppressor to your FN SCAR firearm, make sure you are in full compliance with all federal, state and local laws and regulations regarding such items. Failure to fully comply with these laws and regulations could result in serious legal consequences.

The installation of a sound suppressor (silencer) on a firearm will affect the operating characteristics of that firearm, may interfere with the safe and reliable operation of the firearm, and could result in firearm damage, personal injury or death. The actual effect on the firearm is dependent on the combination of firearm design, suppressor design, and ammunition type used. The use of a suppressor on your FN firearm introduces variables outside of FN's control. FN cannot account for every possible suppressor and ammunition combination that might occur in conjunction with the firearm. Therefore, any and all use of a suppressor with your FN firearm is at your risk and voids the warranty for any malfunctions or damage that may result.

WARNING:

When changing caliber, be sure of which caliber is installed in the rifle before firing. Using the wrong ammunition may create an unsafe condition resulting in damage to the firearm, personal injury or death.

CAUTION:

When changing barrels on the FN SCAR, or any firearm, the headspace must be checked by a certified armorer or gunsmith using a set of GO/NO-GO headspace gages for the caliber of the barrel. An unsafe condition could occur if the bolt and barrel combination do not meet the specified headspace dimensions for that caliber.